

Date: Thursday, 3/13/2008 10:19:28 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001~Dart Helicopters Services	Drawing Name	: STEP LEG
Job Number	: 37925A		
Estimate Number	: 10353		
P.O. Number	:	Part Number	: D2278
This Issue	: 3/13/2008 S.O. No. :	Drawing Number	: D2278 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: F
Previous Run	: 37452A	Material	:
Written By	:	Due Date	: 3/28/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>1080313</u>		
Comment	: Est Rev:A New Issue 05-11-07 JLM		
	: Est Rev:B Now 6061-T6 06-06-23 JLM		
	: Est Rev C New flat pattern 08.01.11 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080;	6061-T6 .080 Sheet
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MAT NOT PULLED



Comment: Qty.: 1.0306 sf(s)/Unit Total : 20.6115 sf(s)
 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick
 (M6061T6S.080)
 Identify as D2278
 Batch: 107460 IB 8-3-26

MAT USED 2024

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2278
 Dwg Rev: F
 Prog Rev: F

IB 8-3-26

(21)

2-Deburr if necessary IB 8-3-26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-3-26



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/03/26 (421) counters

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2278 PAR #: NA Fault Category: Prod / P/B ^{mod of Sml} NCR: Yes No DQA: D Date: 02/03/07
 QA: N/C Closed: D Date: 02/03/08

NCR: <u>37925A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.03.27	1.0	MAT'L IS 2024-T3 INSTEAD OF 6061-T6.	<u>[Signature]</u> 08.03.27	2024-T3 IS STRONGER THAN 6061-T6. ACCEPTABLE DEVIATION PER Q51 012.	<u>[Signature]</u> 08.03.27	<u>[Signature]</u> 08/03/28	<u>[Signature]</u> 08.03.27	<u>[Signature]</u> 08/03/28

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:19:28 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 37925A

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(21)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-03-26

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(21X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-A 08/02/26

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: C-A

SB 08'03/26 21

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(21)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

Job Completion



MF

08-03-27

(21)

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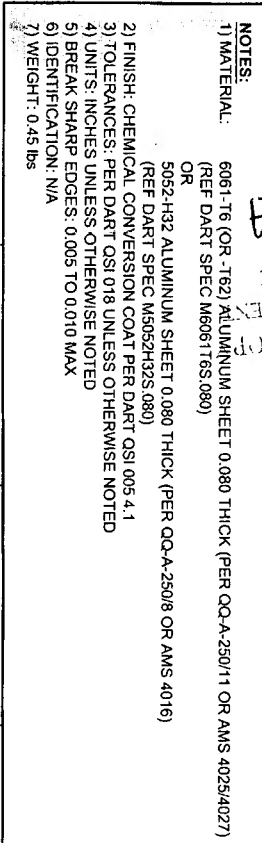
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2278 LEG

F	CHANGE 00 213 HOLES TO 00 213 X 0.750 SILOT CHANGE SOME DIMENSIONS TO X.XX FROM X.XXX UPDATE PROFILE AND FORMAT. REF NCR 263	PH	07.12.27
E	ADD 8061-1-B MATERIAL	CB	06.05.29
D	ADD FINISHING NOTE	PH	05.11.14
C	CHANGED RADIUS TO 0.354	BW	95.02.16
B	CHANGED TO MATCH SPACERS	BW	94.11.03
A	NEW ISSUE	BW	94.10.18
REV.		BY	DATE
DESIGN			
DRAWN	<i>AA</i>		
CHECKED			
MFG. APPR.	<i>AK</i>		
APPROVED	<i>AK</i>		
DE APPR.	<i>AK</i>		
DATE	07.12.27		
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RELEASED
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